

Date: Wednesday, 6/14/2006 1:05:52 PM
 User: [redacted]@celle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DUMP OUTLET	
Job No. :	27543			
Estir. Number :	12131			
P. Number :	NIA	Part Number :	D34757	
Issue :	6/14/2006	S.O. No. :	NIA	
Issue Rev. :	NC	Drawing Number :	D3475 REV B	
First Issue :	NIA	Project Number :	N/A	
Previous Run :	26176	Drawing Revision :	B	
	Type : SMALL /MED FAB	Material :	NIA	
Written By :	SEE COMMENT BELOW		Due Date :	6/16/2006
Checked & Approved By :		Qty:	10	Um: Each
Comment :	Est Rev:A New Issue 06-01-31 JLM Est Rev:B As per Rev B 06-05-24 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1308 For D3475-7S

Spin as per Dwg D3475

Possible Supplier: SIEG

Material release note is required

C 205/30/06

2.0	D3475S	SCOOP OUTLET SPINNING DETAIL
-----	--------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 scoop outlet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 206/04/06

(10)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Sp

06/06/14

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scribe line at .180" Below center line of part

2-Rough Cut Part on Band Saw Leaving some Material.

06.06.16



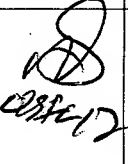
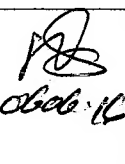
10

POSITIVE
RECALL
Proceed
to step 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/06/16	5	1 piece the angles was 15° has to be 10°	 06/06/16	Scrap + destroy	SB 06/06/15	 06/06/16	 06/06/16	 06/06/16

NOTE: Date & initial all entries

Date: Wednesday, 6/14/2006 1:05:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 27543

Part Number: D34757

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Using DT8842 Angle Block,Sand Part on Disk Sander to Scribed line.

4-Transfer Punch Using DT8843,Then Drill as per Dwg D3475.

5-Deburr.

FF 06.06.16 12

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.06.16 SB 06/06/16 (9) PTO

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06/06/16 (9)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/16 (9)
W 06.06.16

Job Completion



POSITIVE RECALL

EFFECTIVE 06-06-14 AUTH

RELEASED DATE

06/06/14
Proceed to
Step 5
06.06.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

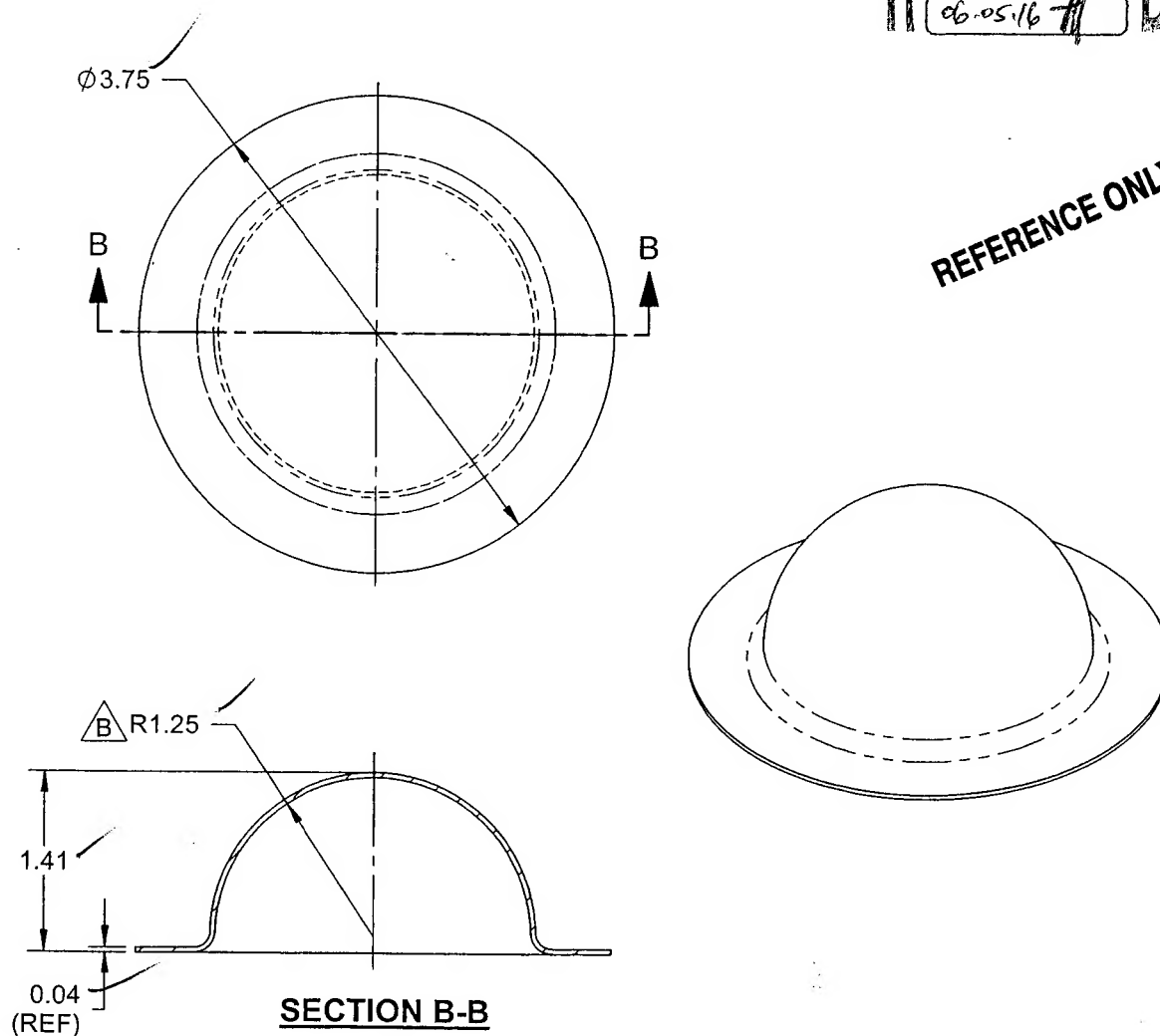
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3475	REV. B SHEET 5 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

RELEASED
06.05.16 [Signature]



D3475-7S SCOOP OUTLET, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CUSTOMER 02510		SHIP DATE 02/17/06 SHP		GROSS WEIGHT 211		QUOTE 38-259436-1		OF 1		PACKING LIST																																																	
BILL TO SIEGS MANUFACTURING LTD.		WORK ORDER W*		ORDER DATE 02/03/06 ORD		DELIVERY DATE 02/17/06 DEL		SHIP BRANCH 38 (17)		TEST RESULTS																																																	
SIEGS MANUFACTURING LTD. 6236 - 205 STREET LANGLEY BC CANADA		V2Y 1N7		01		19044 95A AVENUE, BARRY HRT'NTH COLUMBIA, CANADA VAN		38-VAN		UY2370																																																	
CUSTOMER P.O. NUMBER ARLA		TERRITORY 02		ENTRY ID 38JJD		Copper and Brass Sales Canada A ThyssenKrupp Materials NA Company		ThyssenKrupp																																																			
BUYER ARLA		INSIDE SALES JOE J. DILLIELLO				INVENTORY		26.78 LB		27.00																																																	
BUYER TELEPHONE (604) 530-7455		INSIDE SALES TELEPHONE (604) 882-3493 223				BILLING		1.00 PC		1.00																																																	
INTERNAL		COMPLETE X		PARTIAL		CANCEL		WAREHOUSE																																																			
TO CUSTOMER OUR TRUCK/FRT-BESTWAY-JAG1		FOR ORIG		PACKED WITH OTHER GOODS																																																							
BILL OF LADING		FREIGHT STATUS PPD		FINISHED GOODS LOCATION		WARN LABEL:1005																																																					
AIRCRAFT QUALITY 2024-O CLAD ALUM SHEET, .040 X 48 X 144 -SIEGS MANUFACTURING LTD. ***, NO PROCESSING - 48" X 144" Mill Dimensions., PVC Clear 1 Side. Test Results Attn to: QA Department. , **ok to ship as per P Walsh **all sheets, must be squared and flat on each skid-please ensure each skid has 2 X 4 , legs cut and placed on bottom of skid (along 48" width) for easy forklift , access. **each size to be sep. on indiv.																																																											
<table border="1"> <tr> <td colspan="2">FULL</td> <td colspan="2">SCRAP</td> <td colspan="2">FILLED BY USA</td> <td colspan="2">PACKED BY</td> <td colspan="2">QA AUDIT</td> <td colspan="2"></td> </tr> <tr> <td colspan="4">CUSTOMER RECEIVING HOURS 7-3:30pm, avoid 11:3</td> <td colspan="2">MAX SKID WEIGHT 3000</td> <td colspan="2">LOADING INSTRUCTIONS FORK</td> <td colspan="2">MAXIMUM SKID WEIGHT 3000</td> <td colspan="2"></td> </tr> <tr> <td>BOXES</td> <td>UNGS</td> <td>CASES</td> <td>CLIP-UP</td> <td>PKGS</td> <td>SKIDS</td> <td>ROLLS</td> <td>TUBES</td> <td>CTNS</td> <td>FLAT</td> <td>COILS</td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>1</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>												FULL		SCRAP		FILLED BY USA		PACKED BY		QA AUDIT				CUSTOMER RECEIVING HOURS 7-3:30pm, avoid 11:3				MAX SKID WEIGHT 3000		LOADING INSTRUCTIONS FORK		MAXIMUM SKID WEIGHT 3000				BOXES	UNGS	CASES	CLIP-UP	PKGS	SKIDS	ROLLS	TUBES	CTNS	FLAT	COILS								1					
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TEST RESULTS

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

QQ-A-250/5

AMS 4040

ASTM-B209

TAC NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
1.00 PC ALCOA I 08G6265 533531

PCS : TAC NO

QUANTITY UOM VENDOR VEND PO HEAT/LOT

000

DAVID K. BARBER

General Manager, VANCOUVER

COPPER AND BRASS SALES CANADA IS A DIVISION OF THYSSENKRUPP MATERIALS, CA, LTD./USA

PRINTED 02/15/06 11:56 AM

CONTROL NO 00082

Dant.
613-632-1053 4 Pages

Attn: Gerry
604-530-7490

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material match the composition data and that the mechanical properties shown on the face of this sheet are

Mark J. Winkler

Mark J. Winkler
Director of Manufacturing Davenport Works

Kurt F. Young

Kurt F. Young
Quality Assurance Manager

205131
Ship Date

2003-01-10

P.O. No./Govt Contract No.

866265

9050
B.I. No.

24546

Invoice No.

56912

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-56734-1

Page 1

Ship To: COPPER & BRASS SALISS INC
WALLINGFORD BRANCH
5 SPERLING DRIVE
WALLINGFORD, CT 06492

Item Description

.040 IN TH (+.0000 -.003) X 48 IN W X 144
IN LN (N) A/T ALCLAD 2024-O FLAT SHEET MILL FINISH (PART 752603-
1) RAMMA 02-182-030, PER (EXC GA TOL) AMS-QQ-A-
250/5 REV A & EXCEPT MARKING
ASTM B209 REV 02 & EXCEPT MARKING AMS4040 REV M
({MARKED}) INTERLEAVED MAX GROSS
SKID WGT: 2400 LB QURN TOL +/-30 %
CQR 0137587 REV 01 QRR 000879 CUST REQ 02-12-
15 *** W/R 02-12-21 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	639714	533531	2035	77	PC	
2	639810	533511	795	30	PC	
3	639812	533531	2011	77	PC	
4	639813	533531	2115	81	PC	
5	639814	533531	2039	77	PC	
			8995	342		

Notes for CQR: 0137587.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/5 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/5.

CQR: 0137587.1 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
0	Long Transv.	Max 30.0	14.0	PCT
		Min		12
Temp	Dir	UTS	TYS	ELAD
742	Long Transv.	Max 57.0	34.0	15
		Min		15
Temp	Dir	UTS	TYS	ELAD
742P	Long Transv.	Max 57.0	34.0	15
		Min		15



SIKORSKY

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material and the composition have been taken and have the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

205133
Ship Date9050
B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2003-01-10

24546

56912

DS-56734-1

P.O. No./Govt Contract No.

Customer

066265

C&B-MALLINGFORD

CQR: 0137587.1 -Specification Limits (cont.)

Temp	Dir	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	Max		
		Min	60.0	47.0
				5

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
									Each	Total Aluminum
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05
	Min			3.8	.30	1.2				.15

REMAIN

Chemical Composition	SI+FE	CU	MN	MG	V	ZN	TI	Other
								Each Aluminum
LINER	Max	.70	.10	.05	.05	.10	.03	.03
Alloy 1230	Min							

99.30

Lot: 533511 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
0	Long Transv.	2	Max	23.4	12.5
			Min	23.4	11.4
					20

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42	Long Transv.	2	Max	60.8	37.6
			Min	60.5	37.5
					19.5

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42P	Long Transv.	2	Max	62.5	38.4
			Min	62.4	38.2
					25

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	2	Max	61.8	49.4
			Min	61.6	48.9
					9

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 3

We hereby certify that the material examined by this certificate has been inspected and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and the samples represent the material in the condition shown and that the material conforms to the description in a true and correct manner.

Mark Allen

Ken P. Young

Ken J. Young
Director of Manufacturing Inspection Works

Ken P. Young
Quality Assurance Manager

205131
Ship Date
2003-01-10

9050
B.I. No.

Invoice No.

Alcoa No. Item

DS-56734-1

P.O. No./Order Contract No.

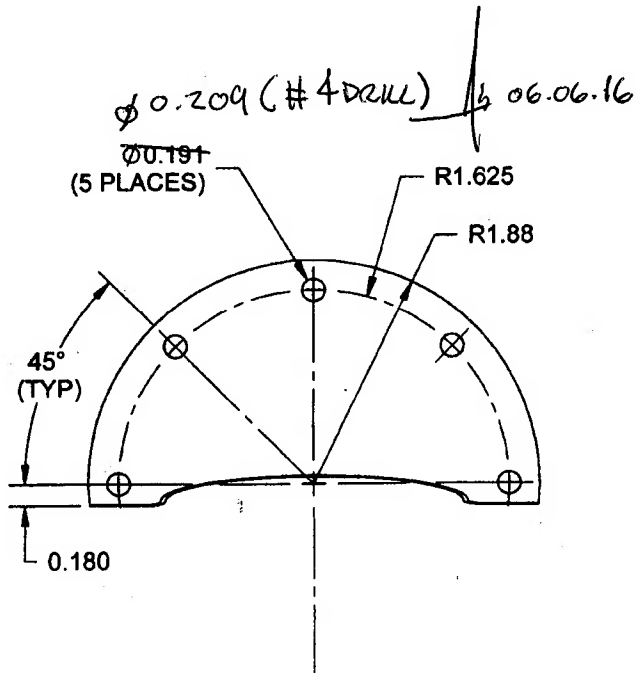
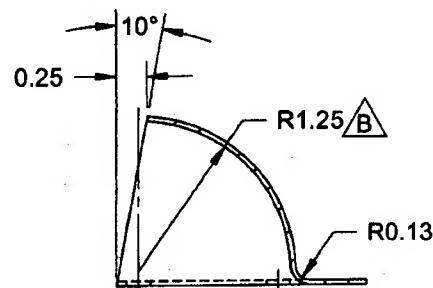
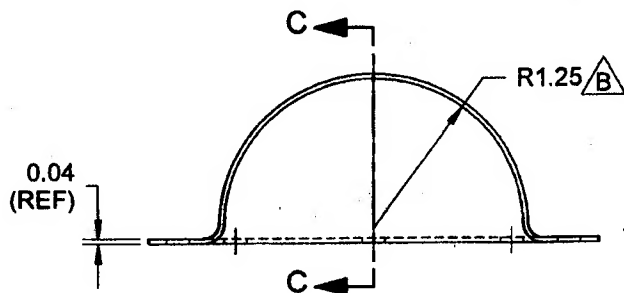
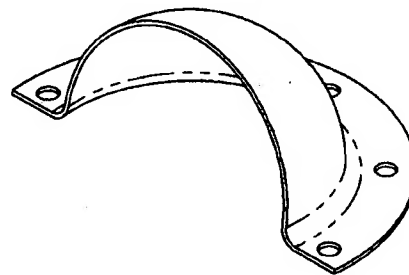
Customer

C&B-WALLINGFORD

Lot: 533531 - Mechanical, Physical, Metallurgy, Quantometer Results (cont.)
Cast Number Chemical ST PE CU HAN MG CR ZN TI
H9532815 Actuals .07 .17 4.6 .64 1.6 .01 .10 .03

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

**RELEASED**
06.05.16**SECTION C-C****D3475-7 SCOOP OUTLET****NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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